## Work Order ID 64498

Tuesday, December 07, 2010 8:51:44 AM



Page 1

Pevision ID:	D4114-1 Door Doubler,	LH		Accept				_	tart
	12/7/2010	Start Qty: 4.00 Req'd Qty: 4.00	1		Cust Item I Customer:	D:			1 10011110
Approvals:	Process Plan	n:	Date:/ <i>O-()</i> 7	Tooling: SPC (Y/N):		ate:			tart
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID		Plan Acce	pt Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revi	ision Nbr							
D4114	Α		•						
100 Waterjet		Memo		0.00				1310-13	<u> </u>
FLOW CNC Waterj		1-Cut as Dwg Rev Prog Rev	1					7	4
110		QC2- Inspect parts of	if necessary f machine FAI/FAIB	0.00				_	
QC Quality Control		Memo		0.00				B10-10	-16

	-								
W/O:			WO	RK ORDER CHANC	GES				6
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	D	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQA:	Date: _	
	Re	esolution:	Disposition	າ:	QA: N/C	Close	d:	Date: _	
NCR:			WORK ORDI	R NON-CONFORM	ANCE (N	CR)			
DATE	OTED	Description of NC	·		ction B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector
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**Required Date: 12/20/2010** 



Tuesday. December 07, 2010 8:51:44 AM

Item ID:

D4114-1

Accept



Run

Setup Start

Stop



Revision ID:

Item Name: Start Date:

Door Doubler, LH

12/7/2010

QC:

Start Oty: 4.00

Rea'd Otv: 4.00

Cust Item ID:

Customer:

Reference:

**Approvals:** 

Process Plan: \_\_\_\_\_\_

Date: \_\_\_\_\_\_

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop



Sequence ID/

Work Center ID

120

Quality Control

Operation Description

OC8- Inspect parts - second check

Memo

Set Up/ Run Hours

Tool ID

Tool # Plan Code

Accept Oty

Reject Qty

Reject Number Stamp

Insp.



Memo

Memo

1- C'sink holes as per dwg

0.00

0.00

Small Fab

QC

140

Quality Control

QC5- Inspect part completeness to step on W/O

J'w112/17

0.00



W/O:	<u>.                                    </u>		WO	RK ORDER CHANG	ES				€
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del> </del>									
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DO	)A:	Date: _	
	Re	esolution:	Disposition	:	_ QA: N/C (	Closed: _		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Action Description			ication tion C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Dat	e			

#### Work Order ID 64498

**Required Date: 12/20/2010** 

Tuesday, December 07, 2010 8:51:44 AM



Page 3

Item ID:

D4114-1

Accept

Setup Start

Stop



Revision ID:

**Start Date:** 

Item Name:

Door Doubler, LH

12/7/2010

Start Otv: 4.00

OC:

Req'd Oty: 4.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Run Start

Stop

Sequence ID/

Work Center ID 150

Packaging

Operation Description

Identify as per dwg & Stock Location: 1333

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Packaging

Memo

0.00

160

Quality Control

OC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/20 Ty

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W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								,			
Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	s No DC	QA:	Date: _			
	R	esolution:	Dispositio	n:	QA: N/C	Closed: _		Date: _			
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	CR)			-		
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sigi		ication	Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng	Da		tion C	Chief Eng	QC Inspector		
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#### Picklist Print

Tuesday, December 07, 2010 8:51:48 AM

Work Order ID: 64498

Parent Item:

D4114-1

Parent Item Name: Door Doubler, LH



Start Date: 12/7/2010

Required Date: 12/20/2010

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	124.0000	0.25	1.052632	·		
										IB.	10-17-	16	

304/316 Sheet .063

<b>Location</b>	Loc Qty	Loc Code	
MAT	124		
111323	0		
115953	124		115953

W/O:			WO	RK ORDER CHANG	GES				?
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
								Prod Mgr	QO MOPOOTO
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	Reso	olution:	Disposition	1;	QA: N/C (	closed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ction B	Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
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					:				
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DART AEROSPACE LTD	Work Order: 6449 %	
Description: DOOR Doubles LH.	Part Number: D 4(14-1	
Inspection Dwg: D 4114-1 , Rev: A	Page 1 of 1	

# FIRST ARTICLE INSPECTION CHECKLIST

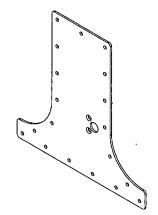
X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
\$ .138	1.005001	-128	×		1BX02	
\$ .374	+ 006 - 001	-375	8		ν	
,35	4 ,036	751	7		V	
7,750	4 ,010	7,756	<b>&gt;</b>		V	
1.136	4 .010	1.175	<b>D</b>		V	,
7.75	4 .030	2,750	٧		V	
. 754	4 010	727	8.	<u> </u>	V	
.508	12 -010	.508	4	<u> </u>	U	
6.00	42 .320	6.011	194		V	
،٦ج	2 .030	.754	7		V	
.75	42 .030	.751	D		U	
3.50	4 -530	51507	Æ		U	
1.10	4 .030	1.098	7		U	
6.00	42 .030	6.04	2		V	
.64	4/30	. 644	>		V	·.
1.38	4 .030	1.382	¥	<u> </u>	V	
<b>26</b> . 6	TL -030	7.704	В		V	
75.	4 000	,746	7		V	
3.30	72 -030	3.798	75		V	
1.10	4, 30	1.098	Z		V	·
£20,		1058	7		V	

Measured by:	A	Audited by:	Prototype Approval:	
Date:	10 ×2 ×1	Date: 10/12/16	Date:	
L	10 10 10	T. NOTICE		

Boy	Date *	Change	Revised by	Approved
Rev	Date		KJ/JLM	
A		New Issue		

D4114-1 DOOR DOUBLER, LH



**D4114-2 DOOR DOUBLER, RH** 

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4440 S

BA 10-12-7

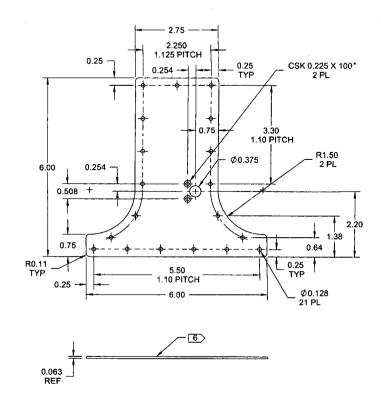
DELEASED 2010 -09- 23

A	NEW IS	SUE		JPH	10.07.20					
REV.			DESCRIPTION	BY	DATE					
DESIG	١	JPH	DART A	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
DRAW	4	JPH								
CHECK	ED	.13	DRAWING NO.							
MFG. A	PPR.	X.	D4114		SHEET 1 OF 2					
APPRO	VED	W	TITLE		SCALE					
DE APPR.			<ul> <li>DOOR DOUBLE</li> </ul>	R	NTS					
DATE	10.0	7.20	THIS DOCUMENT IS PREVATE AND CONFID	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PREMATE AND CONFIDENTIAL AND IS LIPPLED ON THE COPYRESS CONSTROL THAT IT IS NOT TO BE LIEDD FOR ANY PRIPOSES OR CODE OR COMMANDATED TO ANY OTHER PERSON WITHOUT						

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W/O:			W	ORK ORDER CHANG	GES					•
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									<u></u>	
Part No:		PAR #:	Fault Cate	NCF	ICR: Yes No DQA: Date:					
	Re	esolution:	Dispositio	QA:	N/C CId	sed:		Date:		
NCR:		,	WORK ORD	ER NON-CONFORM	IANCE	(NCR	)		***	
DATE	STEP	Description of NC Section A			ction B	Verification		Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	<b>I</b>	Sign & Date		tion C	Chief Eng	QC Inspector

2.250 2.10 1.125 PITCH - 0 25 0.25 CSK 0.225 X 100° TYP 2 PI 3.30 1.10 PITCH 30 R1.50 Ø0.375 0.254 ററ്റ 2 PL + 0.508 2012 .574 0.64 0.75 0.25 5.377 R0.11 5.50 1400 TYP TYP 1.10 PITCH Ø0.128 6.00 21 PL 0.063

**D4114-1 DOOR DOUBLER, LH** 



**D4114-2 DOOR DOUBLER, RH** 

w/o 64498

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4114 MFG, APPR SHEET 2 OF 2 APPROVED TITLE SCALE DOOR DOUBLER DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS REVAILE AND COMPRISH TO ANY OTHER PRISES CONDITION
THOSE COLD FOR ANY PURPOSE OF COMPANIES TO ANY OTHER PERSON
WINTTENDED AND ANY PURPOSE OF COMPANIES THE PRISES OF THE P DATE 10.07.20

NOTES: 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA

С

2) FINISH: NONE.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENT P/N D4114-X & B/N PER QSI 044 6.1
7) WEIGHT -1 & -2: 0.35 lbs

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W/O:			WO	RK ORDER CHANG	GES		<del> </del>		٠, ;
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Categ	NCR: Yes No DQA: Date:					
	R	esolution:	Disposition	1:	QA: N/C Closed: Date				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A		ection B		cation	Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
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